

Date: Monday, 6/5/2006 7:47:39 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR  
 Job Number : 27371  
 Estimate Number : 12264  
 P.O. Number : NIA Part Number : D3140103  
 This Issue : 6/5/2006 S.O. No. : NIA Drawing Number : D3140 REV D1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : NIA Type : SMALL /MED FAB Drawing Revision : D1  
 Previous Run : 25736 Material : NIA  
 Written By : Sally Comment Bklu Due Date : 6/30/2006 Qty: 4 Um: Each  
 Checked & Approved By : 06.06.05  
 Comment : Est Rev: A New Issue 06-02-08 JLM  
 Est. Rev B 06.04.18 New dwg rev. ecn781 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S032 2024-T3 .032 sheet



Comment: Qty.: 0.0578 sf(s)/Unit Total: 0.2310 sf(s)

2024-T3 .032 " Thick sheet

(M2024T3S032)

Batch: M100284

06 06 07

2.0 ~~SHEAR~~ Water Jet SHEAR



Prog Rev. D1



Comment: SHEAR

Dwg Rev. D1

Cut Blanks 2.88" x 2.88 - as per Dwg D3140

06 06 07 (4)

3.0 SMALL FAB 1 QC2 SMALL & MEDIUM FAB RESOURCE 1



06 06 07 (4)

Comment: SMALL & MEDIUM FAB RESOURCE 1

3.1

1-Deburr

QC8

06 06 08 (4)

2-Cut Angle as per Dwg D3140

4.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

- Deburr


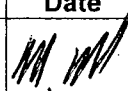
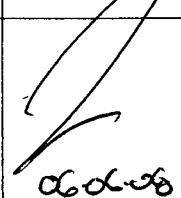

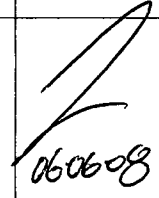
SAP 06 06 10


- Form as per Dwg D3140

SB

06/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-06-08	2	4 parts scrap. Grain in wrong direction.		Scrap - chiseling replace.	 06-06-08	 06-06-08		 06-06-08

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/11

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:47:40 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 27371

Part Number: D3140103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



26-06-13 (4)

Comment: INSPECT WORK TO CURRENT STEP

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M 06-06-13 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C206/13/04 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C206/13/04 (4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

C206/13/04 (4)

Job Completion



U 26-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	<del>06.03.31</del>	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED  
05.12.01

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

**RELEASED**  
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

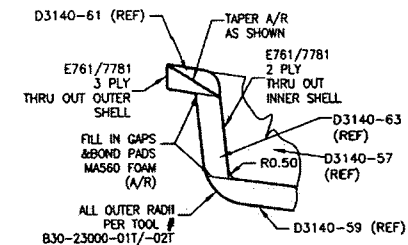
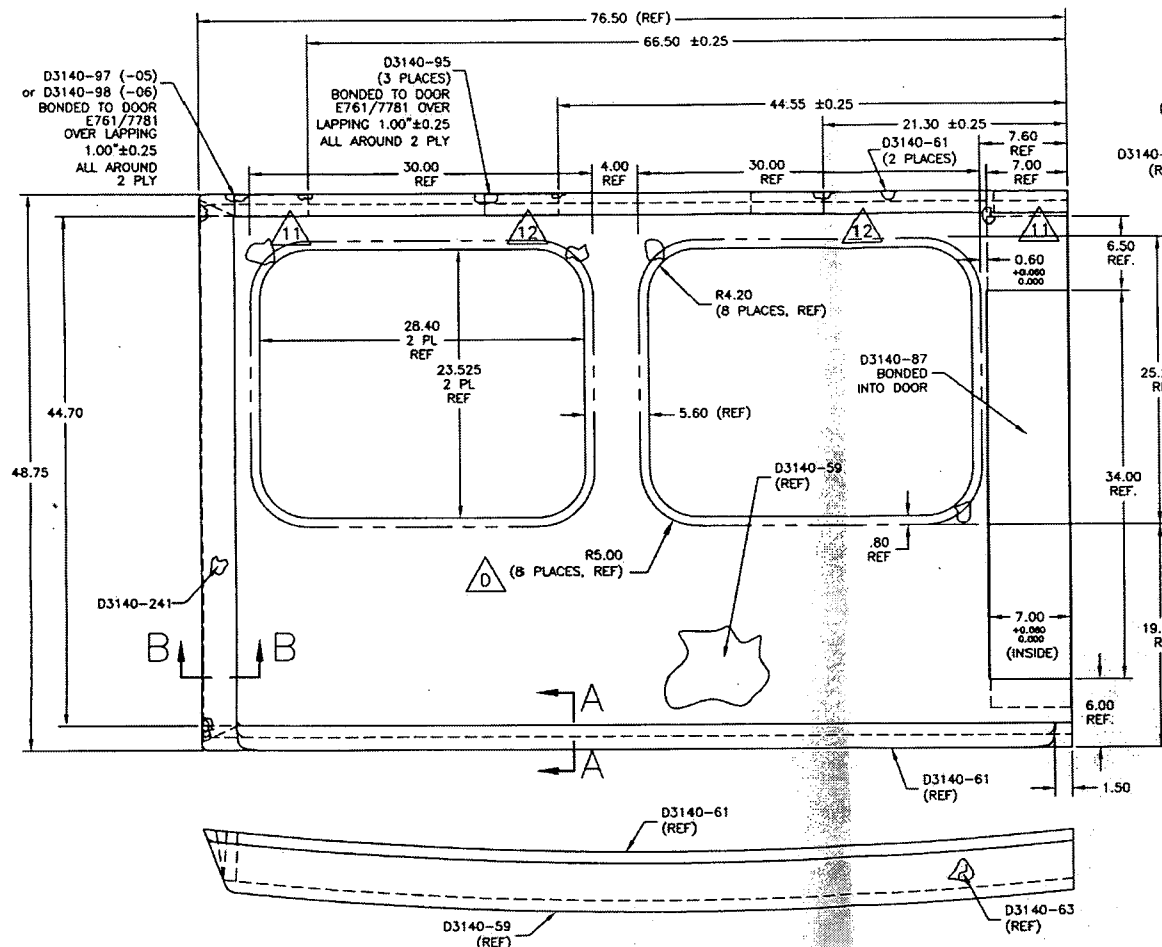
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

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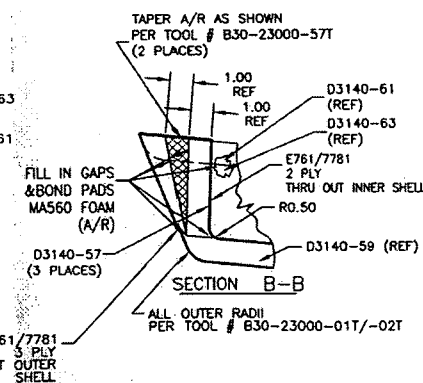
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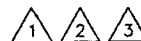
SECTION A-A

RELEASED  
05.11.23



SECTION B-B

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)  
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)  
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

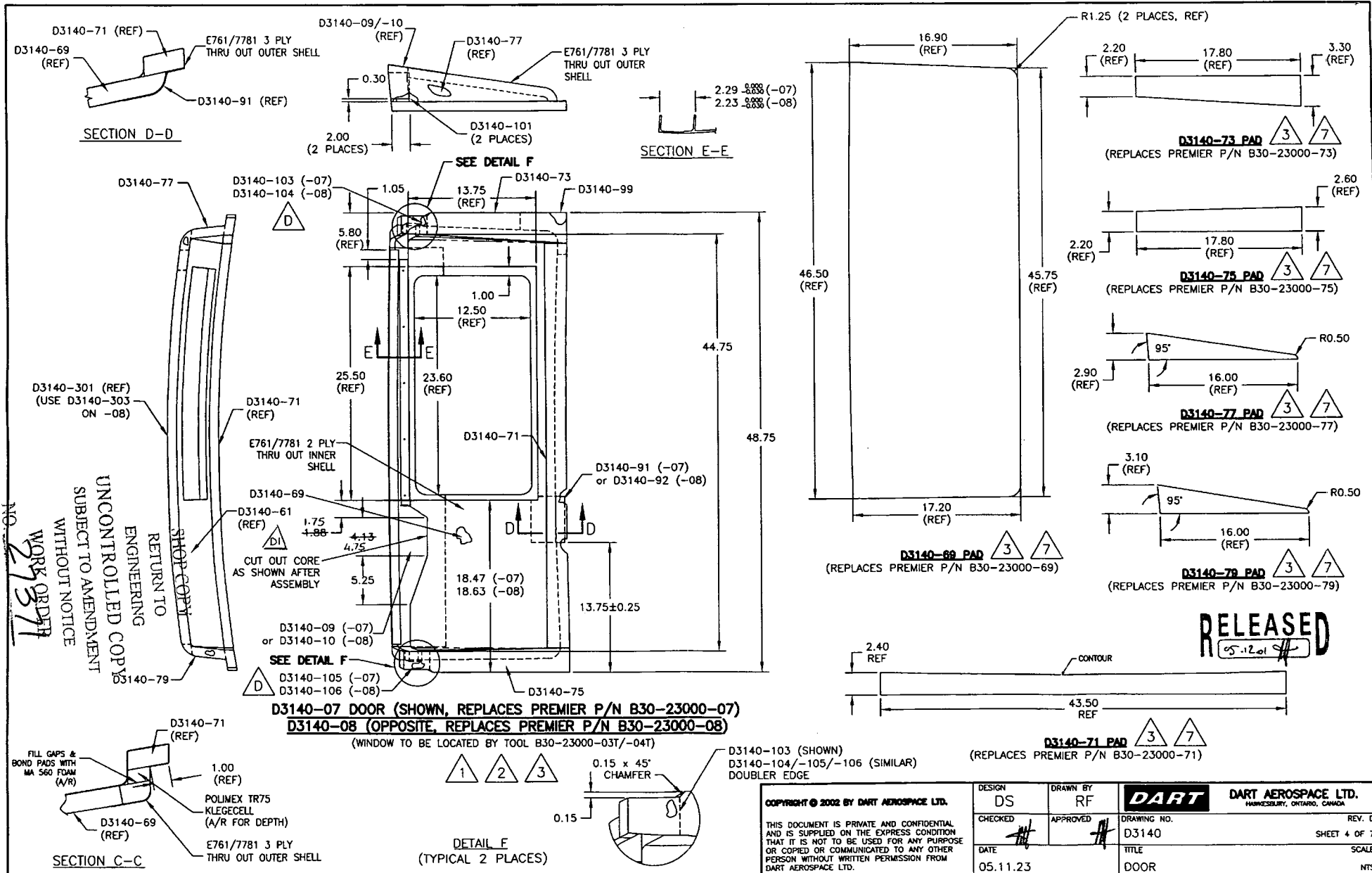


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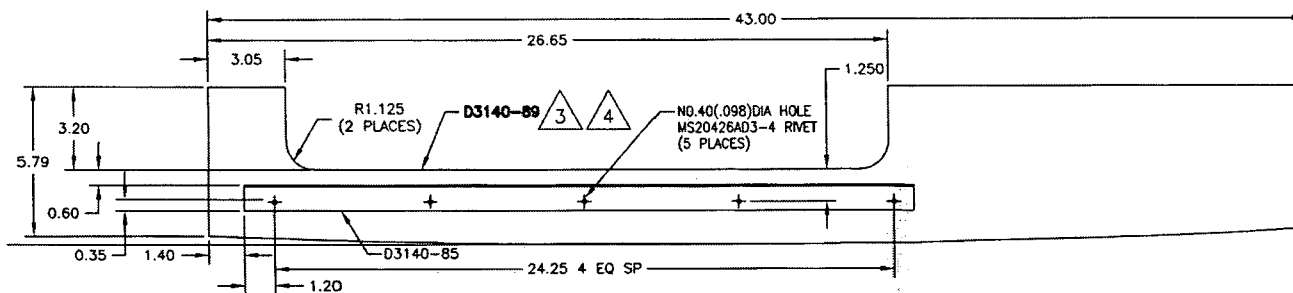
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				TITLE	SCALE
				DOOR	NTS

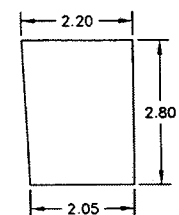
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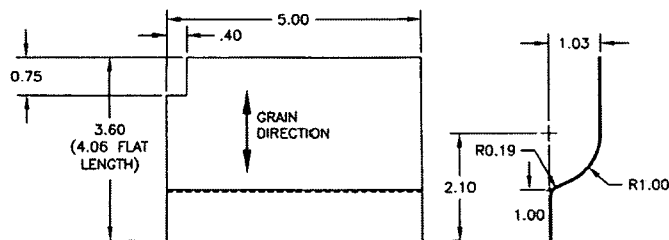




**D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)**  
**D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)**

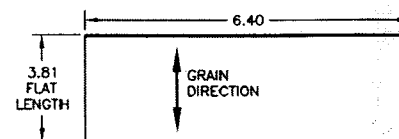


**D3140-101 DOUBLER** (REPLACES PREMIER P/N B30-23000-101)

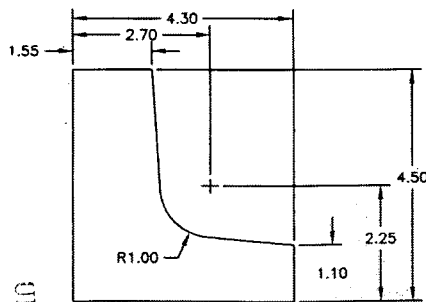
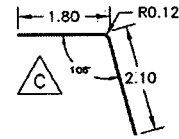


**D3140-91F FLAT PATTERN**  
 (USE TO MAKE D3140-91/-92 DOUBLERS)

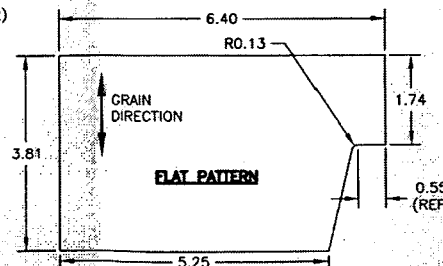
**D3140-91 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-91)  
**D3140-92 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



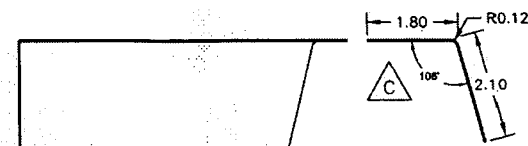
**D3140-95 DOUBLER** (REPLACES PREMIER P/N B30-23000-95)



**D3140-98 DOUBLER** (REPLACES PREMIER P/N B30-23000-99)



**D3140-97F FLAT PATTERN**  
 (USE TO MAKE D3140-97/-98 DOUBLERS)



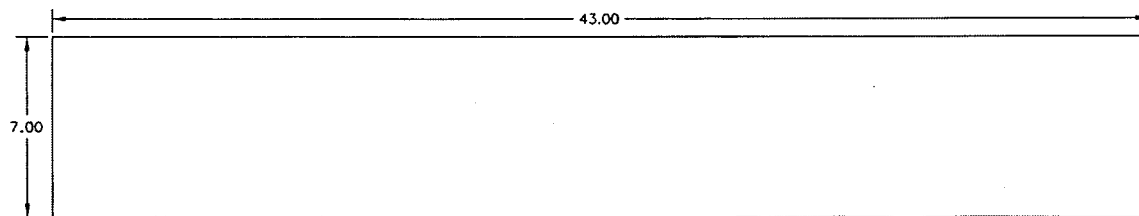
**D3140-97 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

**RELEASED**

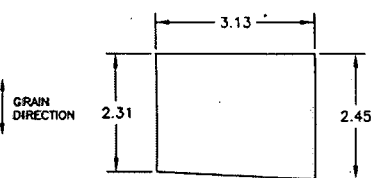
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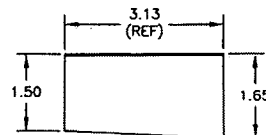
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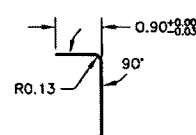
**D3140-87 DOUBLER**  $\triangle 4$   
(REPLACES PREMIER P/N B30-23000-87)



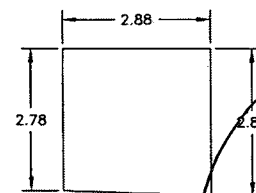
**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)



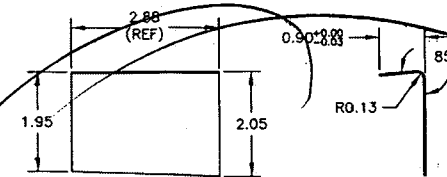
**D3140-105 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-106 OPPOSITE**



GRAIN DIRECTION

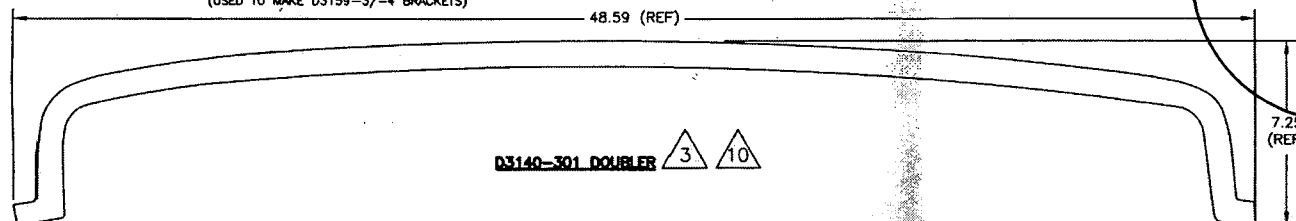


**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)

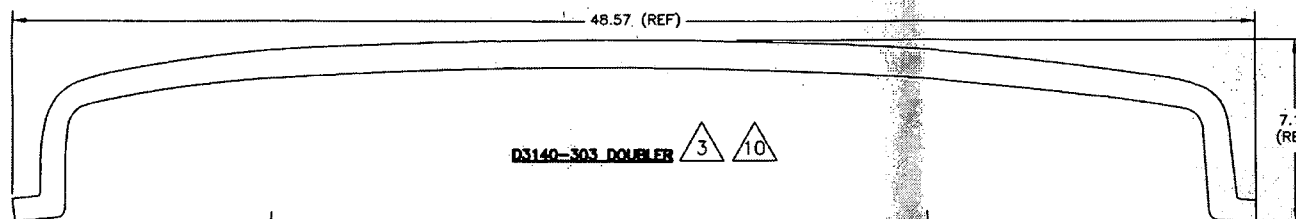


**D3140-103 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-104 OPPOSITE**

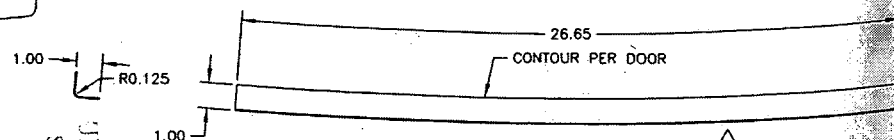
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-303 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-85 ANGLE**  $\triangle 6$   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

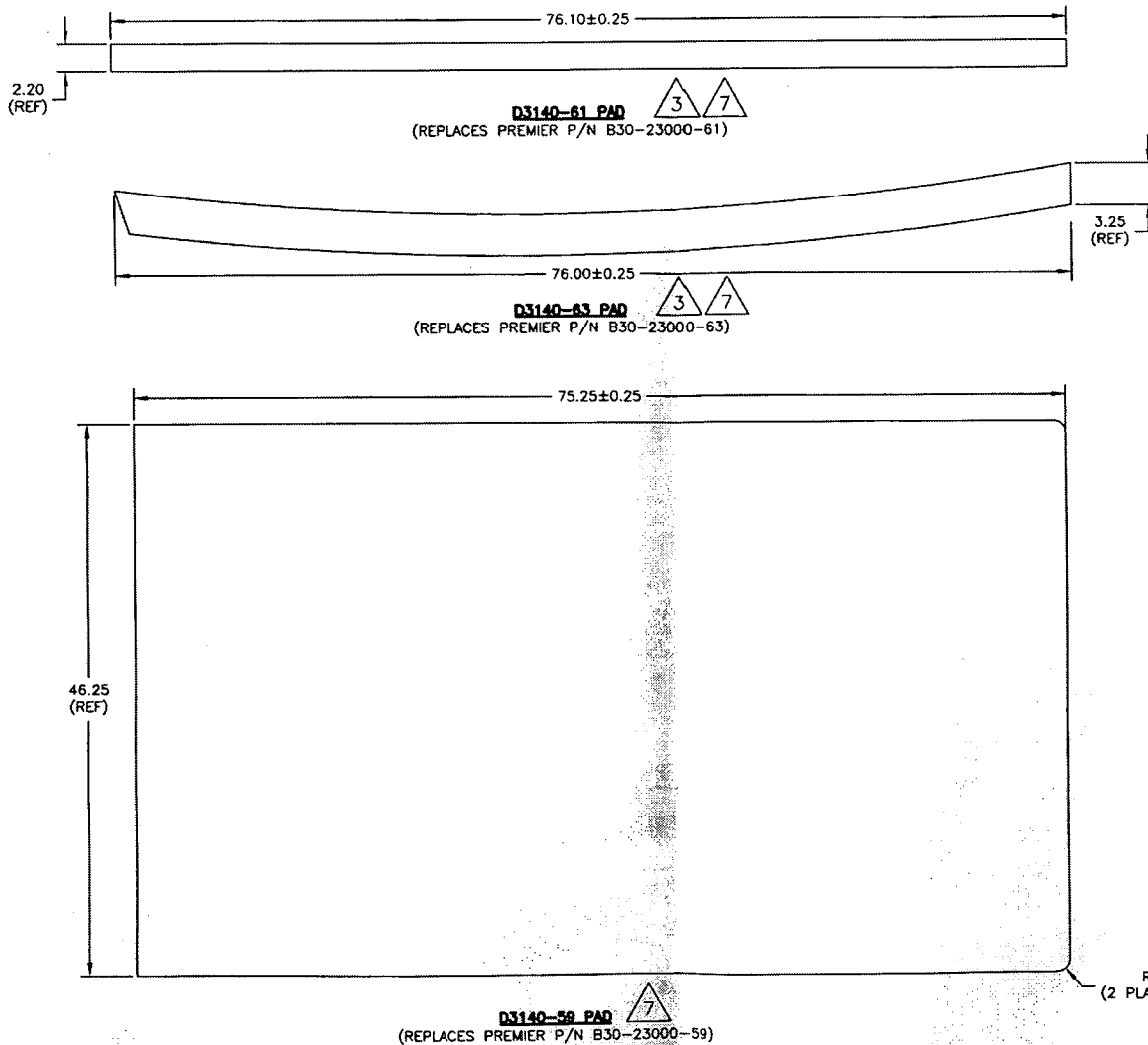
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DATE 05.11.23		TITLE DOOR	SCALE NTS

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DATE 05.11.23		TITLE DOOR	SCALE NTS

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Rev	Date	Change	Revised by	Approved
1		New Issue	KJ/JLM	

